

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

**As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.**

THIS PAGE BLANK (USPTO)

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets

(11) Publication number:

0 322 999
A2

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: **88307524.4**(51) Int. Cl.⁴: **B29C 65/60**(22) Date of filing: **12.08.88**(30) Priority: **31.12.87 US 140194**(43) Date of publication of application:
05.07.89 Bulletin 89/27(84) Designated Contracting States:
BE DE ES FR GB IT LU NL(71) Applicant: **GENCORP INC.**
175 Ghent Road
Akron Ohio 44313(US)(72) Inventor: **Carper, Robert L.**
3429 Pine Creek
Brighton Michigan 48116(US)
Inventor: **Goewey, James R.**
4821 North Brooke Drive
Marion Indiana 46952(US)(74) Representative: **Calderbank, Thomas Roger et al**
MEWBURN ELLIS & CO. 2/3 Cursitor Street
London EC4A 1BQ(GB)(54) **Heat riveting rubber for effecting a mechanical lock.**

(57) A process for mechanically bonding a sheet 10,20 of rubber to a sheet of 12,22 of another, e.g. a reinforcing, material, and a composite article made by the process. A molded sheet 10 of rubber having integral upstanding posts 14 is assembled with the sheet 12 of the other material in such a manner that the posts 14 extend through openings 16 in the sheet 12 of the other material. The distal ends 14A of the rubber posts 14 are then reformed (preferably by heating) to shape or form the rubber posts into rivets 14B which mechanically lock the rubber sheet 10 and the sheet 12 of other material together and provide good shear resistance. According to another embodiment of the present invention, the reinforcement material 22 is a high melting temperature plastic which has an upstanding post and the molded rubber sheet 20 and has openings therein. The plastic posts 26 are reformed as with a laser to bond the plastic sheet 22 to the rubber sheet 20.

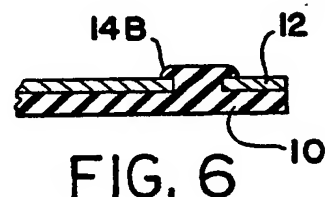


FIG. 6

EP 0 322 999 A2

HEAT RIVETING RUBBER FOR EFFECTING A MECHANICAL LOCK

The present invention relates to a process for mechanically locking a sheet of rubber to a sheet of a reinforcing or attaching material, usually a metal or a high temperature melting plastic. Further, the invention relates to a composite article made by such a process, i.e., a sheet of rubber mechanically bonded to a sheet of another material by means of a rubber rivet that is integrally formed from the sheet of rubber. Alternatively, a sheet of rubber is mechanically bonded to a sheet of a plastic material by means of a plastic rivet integrally formed from the sheet of plastic material.

In the manufacture of parts such as rubber gaskets, it is common practice to reinforce the rubber material with a sheet of another or a reinforcing material such as metal or a high temperature melting plastic. Moreover, it is known to provide an adhesive bond between the rubber and the other material to form a composite sheet which combines the characteristics of both materials.

It has been found that a chemical bond between the rubber and the reinforcing material may break down in certain applications when subjected to certain extreme conditions. For example, when such a composite structure is used to form a gasket for an automobile headlamp, the adhesive (chemical) bond between the rubber and the metal reinforcement may break down under the heat generated by the headlamp. Since the forces applied to such bond are primarily in shear, a breakdown of the adhesive bond can result in significant damage to the gasket.

Accordingly, there is a need to provide a mechanical bond for composite articles wherein rubber is adhered to a reinforcing material, and to provide a mechanical bond which generally resists shear forces which would otherwise tend to break down a chemical bond (i.e. an adhesive joinder) between the materials.

Accordingly, it is an aspect of the present invention to provide a process for mechanically bonding rubber to a reinforcing or attaching material in such a way that the mechanical bond resists shear forces. Another aspect of the present invention relates to a composite article made by such a process.

According to the concepts of the present invention, a rubber part is initially molded with integral rubber posts that can mate with openings (e.g. matingly engage) formed in a reinforcing or attaching material. The rubber part is then assembled with the reinforcing material in such a way that the rubber posts protrude through the openings in the reinforcing material. The distal ends of the rubber

posts are then reformed (that is shaped as by heating), to form a rubber rivet that mechanically locks the rubber part to the reinforcing material. Such a mechanical rivet in association with an adhesive (chemical) bond between the rubber part and the reinforcing material provides a secure coupling of such members and form a composite which resists shear forces that could otherwise fracture or break the adhesive bond.

The composite product made according to the invention basically comprises a rubber sheet and a sheet of a reinforcing material bonded thereto with a rubber rivet integrally formed from the rubber sheet and effective to resist separation of the members mechanically, under both tension and especially shear forces.

According to other concepts of the present invention, a high melting temperature plastic is initially molded having integral plastic posts which can mate with an opening in a rubber sheet. The posts can be transformed into a rivet through the use of localized heat such as that generated by a laser.

The present invention will be better understood by reference to the following drawings of, and to the detailed description of, embodiments of the invention.

Fig. 1 is a side elevational view of a rubber part for use in forming a composite according to an embodiment of the present invention;

Fig. 2 is a top plan view of the rubber part of Fig. 1;

Fig. 3 is a side elevational view of a metal reinforcing part forming part of the composite according to this embodiment;

Fig. 4 is a top plan view of the metal part of Fig. 3;

Fig. 5 schematically illustrates the manner in which the rubber and metal parts are contiguously assembled with posts of the rubber part extending through the metal reinforcement;

Fig. 6 is a schematic fragmentary cross-sectional view of the mechanical interlock between the metal and the rubber part; and

Fig. 7 is a cross-sectional view of a mechanical interlock between a plastic sheet and a metal sheet according to another embodiment of the present invention.

Figs. 1 through 4 show the basic profile of a rubber sheet 10 and a reinforcing sheet 12 which are mechanically interlocked according to the concepts of the present invention. As seen in Figs. 1 and 2, the rubber sheet 10 includes a pair of integral, upstanding posts 14. As seen in Figs. 3

and 4, the reinforcing sheet 12 has a pair of openings 16 positioned or dimensioned to mate with the rubber posts 14 on the rubber sheet 10.

The rubber material of the present invention is generally any elastomer which can be reformed or shaped at high temperatures, for example at about 700° to about 800° F. Naturally, a temperature is utilized which melts or causes rubber posts 14 to flow. Ethylene-propylene type elastomers constitute a suitable class of rubber for use in the present invention. Such elastomers include ethylene-propylene rubber (EPR), ethylene-propylene-diene rubber (EPDM), and combinations thereof. EPDM contains small amounts of non-conjugated diene units therein. That is, as known to the art as well as to the literature, EPDM is made from monomers of ethylene, propylene and various small amounts of a non-conjugated diene generally having from 5 to about 10 carbon atoms with specific examples including pentadiene, hexadiene, norbornene, methylnorbornene, ethylenenorbornene, and the like. The amounts of the various components of EPR and EPDM are well known to the art and to the literature and are generally conventional. The ethylene-propylene type elastomers are generally cured in a conventional manner. However, the high heat reforming temperature is sufficient to break down the crosslinks forming the cured system and permits the elastomer to flow and assume another shape.

Considering the reinforcing sheet 12, it must be able to withstand such high reforming temperatures. It is thus generally any metal such as steel, or it can be a plastic which has a melting point above the reforming temperature.

Preferably, rubber sheet 10, including integral posts 14, is formed as a single, molded article. The reinforcing sheet 12 when metal can be formed by conventional metal forming techniques (e.g., stamping) with the openings 16 integrally formed therein.

In forming a rubber-reinforcing composite, the reinforcing and rubber sheets are assembled with the surfaces 10A, 12A in juxtaposed relation, and with the openings 16 in the metal sheet 12 located over the rubber posts 14 (see Fig. 5). In such a relationship, the distal ends 14A of the posts 14 extend beyond the other surface 12B of the metal sheet. Before rubber sheet 10 and reinforcing sheet 14 are brought together, either one or both of juxtapositioned or contiguous surfaces 10A and 12A are coated with a thin layer of an adhesive. Any conventional adhesive can be utilized including those known to the art and to the literature.

In order to form the mechanical interlock between the reinforcing (e.g. metal) and rubber sheets, a heating element 18 is brought into contact with rubber posts 14, to reform or deform the

rubber posts. That is, distal ends 14A of post 14 are melted and reshaped in the form of a rubber rivet so that a mechanical lock is created between the rubber sheet and the reinforcing sheet. Thus, in Fig. 5, heating element 18 modifies the distal ends 14A of the rubber posts in such a way as to reform, deform, or shape it to the profile shown in Fig. 6. The reformed rubber post 14 includes a retaining lip 14B which faces and can act against the opposite side 12B of the reinforcing sheet, to mechanically retain the rubber and reinforcing sheets together. However, a primary advantage of the reformed rubber post is good shear resistance.

The product made by the process of this invention is shown in Fig. 6. The reinforcing and rubber sheets 12 and 10 are juxtaposed with interfacing surfaces 12A and 10A that are adhesively bonded together. The rubber posts 14 extend through the openings 16 in the reinforcing (e.g. metal) sheet 12, and its reformed or deformed lip 14A forms a rivet head which mechanically retains the rubber and reinforcing sheets 10 and 12 together. Hence, a process has been provided to form a secure and effective mechanical bond. Such mechanical bond, when coupled with the adhesive bond, effectively retains the materials together, especially under shear conditions.

According to other concepts of the present invention, a high melting temperature reinforcing plastic part 22 is initially molded with integral plastic posts 26 that can mate with openings formed in a rubber part or sheet 20. The plastic reinforcing part which is made of a high temperature plastic, that is a plastic having a melting point of at least 500° or 600° F and desirably at least 700° or even 800° F such as polyimide, polyamide, or high melting polyesters, is then assembled with the rubber material in such a manner that plastic posts 26 protrude through the openings of the rubber material. The distal ends of the plastic posts are then reformed utilizing localized heat so as to not degrade the adjacent rubber material to form a plastic rivet that mechanically locks the plastic reinforcing part to the rubber material. An example of a suitable localized heat source is a laser. Other localized heat sources include a directional flame, and the like. The resulting mechanical rivet in association with an adhesive bond between the rubber part and the plastic reinforcing material provides a secure coupling of such members and forms composite which resists shear forces, in a manner similar to that described hereinabove. Otherwise, the remaining aspects of the embodiment containing the integral plastic reinforcing posts and a rubber part having openings or apertures therein is similar to the description set forth hereinabove with regard to Figs. 1 through 6. Hence, the type of rubber material, the mating engagement or location

of openings in the rubber with integral posts 26, the joinder of reinforcing sheet 22 with rubber sheet 20, and the like, is fully discussed hereinabove.

The present invention can be utilized wherever a rubber sheet is reinforced by a metal or a high melting temperature plastic sheet, or the like. A preferred area of use is in the formation of head-light guide gaskets as used on an automobile.

Claims

1. A process for mechanically bonding a rubber part to a reinforcing part comprising the steps of;

(i) forming the rubber part and the reinforcing part one with an upstanding post and the other with an opening, said post on one said part being complementary to said opening on the other part;

(ii) assembling said rubber part and said reinforcing part with said post extending through the opening in said reinforcing part; and

(iii) reforming said post so as to provide a mechanical bond between said rubber part and said reinforcing part.

2. A process according to claim 1 wherein said rubber part comprises a rubber sheet and said reinforcing part comprises a sheet of reinforcing material, said step of assembly of said rubber and said reinforcing part comprising the steps of placing said rubber sheet and said reinforcing sheet together with respective surfaces in juxtaposed relation and with said post extending through the opening with its distal portion extending beyond the opposite surface of said reinforcing sheet, said step of reforming said post comprising the step of reforming said distal portion of said post to lock said distal portion of said post against the opposite surface of said reinforcing sheet.

3. A process according to claim 1 or claim 2, including the step of chemically bonding juxtaposed surfaces of said rubber part and said reinforcing part.

4. A process according to any one of claims 1-3, wherein said reinforcing part is a metal part.

5. A process according to any one of the preceding claims, wherein said rubber part is an ethylene-propylene rubber, an ethylene-propylenediene rubber, or combinations thereof.

6. A process according to any one of the preceding claims, wherein said rubber part is an ethylene-propylene type elastomer.

7. A process according to any one of the preceding claims, wherein said post is reformed by heating.

8. A process according to any one of the preceding claims including forming said rubber part with said post.

9. A process according to claim 8, including the step of forming said rubber sheet and said post as a single integrally molded element.

10. A process according to any one of claims 1 to 7 wherein said reinforcing part is of plastics, said process including the step of forming the reinforcing part with said upstanding post, said rubber part being provided with an opening for receiving said post.

11. A process according to claim 10, wherein said plastic post is reformed by heating with a laser.

12. A composite material, comprising: a rubber sheet having a first surface and a sheet of a different material with a surface juxtaposed to said first surface of said rubber sheet, one of said rubber sheet and said sheet of a different material having a post protruding from its surface and the other of said sheets having an opening mating with said post in such a manner that said post extends through the opening, the distal end of said post having the profile of a rivet for mechanically retaining said rubber sheet to said sheet of said other material.

13. A composite material according to claim 12 wherein said sheet of said other material is a reinforcing sheet.

14. A composite material according to claim 12 or claim 13 wherein said rubber sheet is an ethylene-propylene type elastomer.

15. A composite material according to any one of claims 12 to 14 wherein the first surface of the rubber sheet and the juxtaposed surface of said different material sheet are chemically bonded to each other.

16. A composite material according to any one of claims 12 to 15 wherein said rubber sheet carries said post, and said sheet of different material has an opening mating with said post.

17. A composite material according to claim 16, wherein said rubber sheet and said post comprises an integrally molded rubber element, and wherein said rubber sheet and said rubber element is an ethylene-propylenediene rubber, an ethylene-propylene rubber, or combinations thereof.

18. A composite material according to any one of claims 12-17, wherein said different material sheet is a metal sheet.

19. A composite material according to any one of claims 12 to 15 wherein the sheet of different material is of plastics and carries the post, said rubber sheet having at least one opening mating with said post.

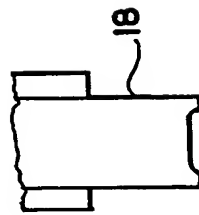
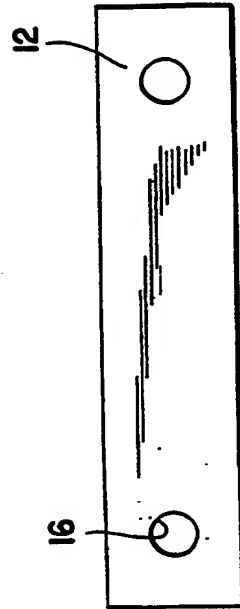
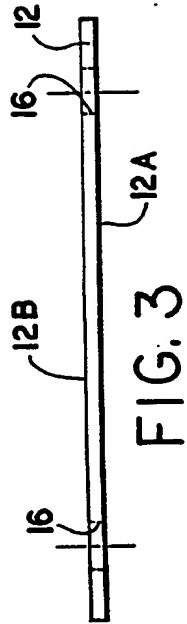
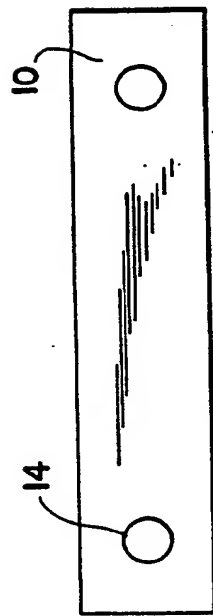
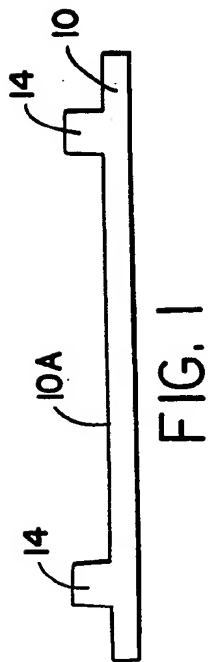
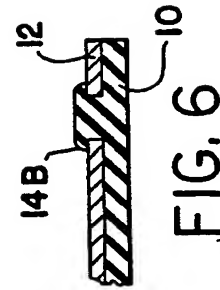
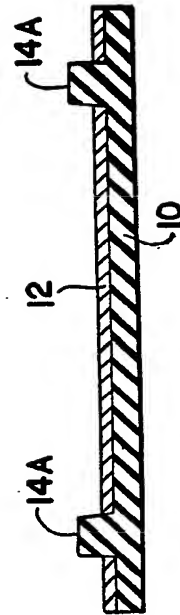


FIG. 5



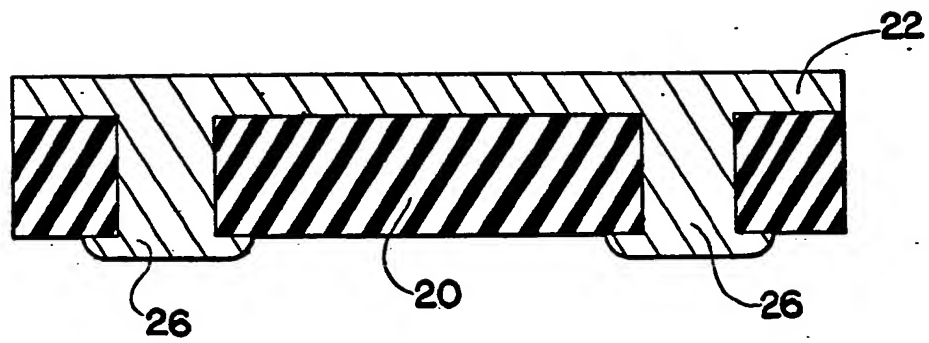


FIG. 7

(19)



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) Publication number:

0 322 999 A3

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: 88307524.4

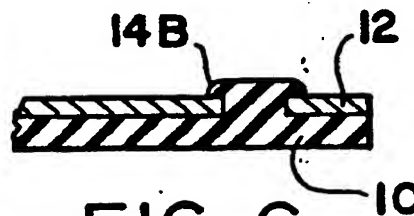
(51) Int. Cl.⁵: **B29C 65/60**

(22) Date of filing: 12.08.88

(30) Priority: 31.12.87 US 140194

(43) Date of publication of application:
05.07.89 Bulletin 89/27(84) Designated Contracting States:
BE DE ES FR GB IT LU NL(88) Date of deferred publication of the search report:
03.04.91 Bulletin 91/14(71) Applicant: **GENCORP INC.**
175 Ghent Road
Akron Ohio 44313(US)(72) Inventor: **Carper, Robert L.**
3429 Pine Creek
Brighton Michigan 48116(US)
Inventor: **Goewey, James R.**
4821 North Brooke Drive
Marion Indiana 46952(US)(74) Representative: **Calderbank, Thomas Roger et al**
MEWBURN ELLIS & CO. 2/3 Cursitor Street
London EC4A 1BQ(GB)(54) **Heat riveting rubber for effecting a mechanical lock.**

(57) A process for mechanically bonding a sheet 10,20 of rubber to a sheet of 12,22 of another, e.g. a reinforcing, material, and a composite article made by the process. A molded sheet 10 of rubber having integral upstanding posts 14 is assembled with the sheet 12 of the other material in such a manner that the posts 14 extend through openings 16 in the sheet 12 of the other material. The distal ends 14A of the rubber posts 14 are then reformed (preferably by heating) to shape or form the rubber posts into rivets 14B which mechanically lock the rubber sheet 10 and the sheet 12 of other material together and provide good shear resistance. According to another embodiment of the present invention, the reinforcement material 22 is a high melting temperature plastic which has an upstanding post and the molded rubber sheet 20 and has openings therein. The plastic posts 26 are reformed as with a laser to bond the plastic sheet 22 to the rubber sheet 20.

**FIG. 6****EP 0 322 999 A3**



European
Patent Office

EUROPEAN SEARCH REPORT

Application Number

EP 88 30 7524

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
X	US-A-4 139 664 (WENRICK) * Fig.; column 2, lines 27-32,62; column 3, line 6 * -- --	1-19	B 29 C 65/60
X	US-A-2 209 403 (KITNER) * Fig. * -- --	1,2,4-14, 16-19	
X	US-A-3 367 809 (SOLOFF) * Column 1, lines 8-46; column 3, lines 38-50 * -- --	1,2,4-11	
Y		3	
X	GB-A-1 312 800 (TING HOK SOU) * Whole document * -- --	1,2,4-11	
Y		3	
Y	GB-A-4 994 33 (METALASTIK) * Page 1, lines 82-103,43-58 * -- --	3	
A		15	
A	ADHÄSION, vol. 27, no. 3, March 1983, pages 10-19, Berlin, DE; W. ENDLICH: "Kleben als multifunktionelle Montagetechnik" * Page 16, point 5 * -- --	3	
A	GB-A-6 078 28 (THE UNITED STATES RUBBER CO.) * Claims * -- --	1,2,4-11	B 29 C
A	EP-A-0 212 656 (TOYOTA JIDOSHA) * Fig. * -- --	1,11	
A	EP-A-0 084 631 (IBM CORP.) * Fig.; abstract * -- --	11	
		-/-	
The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of search 27 December 90	Examiner CORDENIER J.
CATEGORY OF CITED DOCUMENTS X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention E: earlier patent document, but published on, or after the filing date D: document cited in the application L: document cited for other reasons &: member of the same patent family, corresponding document			



European
Patent Office

EUROPEAN SEARCH REPORT

Application Number

EP 88 30 7524

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
A	US-A-3 754 319 (MIORI) * Fig. *		
A	US-A-3 308 225 (WELLS) * Fig. *		
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of search 27 December 90	Examiner CORDENIER J.
CATEGORY OF CITED DOCUMENTS X: particularly relevant if taken alone Y: particularly relevant if combined with another document of the same category A: technological background O: non-written disclosure P: intermediate document T: theory or principle underlying the invention		E: earlier patent document, but published on, or after the filing date D: document cited in the application L: document cited for other reasons &: member of the same patent family, corresponding document	

THIS PAGE BLANK (USPTO)

BEST AVAILABLE COPY